

**LISTING OF CLAIMS, REFLECTING AMENDMENTS:**

What is claimed is:

1. (Currently Amended) A process for casting and curing said cores, in which a core box remains in a fixed vertical plane during core formation, said casting and curing further comprising:

filling a movable blow head with sand;

moving the blow head away from ~~the~~ sand hopper towards the core box;

positioning the blow head in line with a blow valve;

filling the core box with sand from the blow head, wherein the filling includes applying air pressure to the core box through a blow valve and retracting the blow head;  
and

removing excess sand from a core cavity of the core box by introducing a vacuum manifold and returning unused vacuumed sand to the sand hopper for use in the next cycle.

2. (Cancelled)

3. (Currently Amended) A process as defined in Claim 2~~1~~, and including the application of heat to the sand core by introducing an upper burner manifold.

4. (Previously Presented) A process as defined in Claim 3, and including elevation of the cope and core of the core box away from the drag of the core box.

5. (Currently Amended) A process as defined in Claim 4, and transferring the cope and core to a core unloader table, by lowering the cope and core onto the ~~loader~~unloader transfer arms and laterally translating the cope and core to the core unloader table.

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6. (Previously Presented) A process as defined in Claim 5, and including removal of the core from the cope onto the core unloader table.